

Date: Tuesday, 7/24/2007 10:39:02 AM
 User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STIFFNER
Job Number : 33718	
Estimate Number : 12964	
P.O. Number :	Part Number : D36431
This Issue : 7/24/2007 S.O. No. :	Drawing Number : D3643 UNDER REVIEW
Prsht Rev. : NC	Project Number : AC0005
First Issue : 11 Type : SMALL /MED FAB	Drawing Revision : U/R
Previous Run :	Material :
Written By : <i>[Signature]</i> 07-07-24	Due Date : 7/31/2007 Qty: 2 Um: Each
Checked & Approved By :	Verified By:
Comment : Est Rev:A New Issue 07-07-20 JLM	

Additional Product

PROTOTYPE

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S040	2024-T3 .040 sheet
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Comment: Qty.: 0.1549 sf(s)/Unit Total : 3.2524 sf(s)

2024-T3 .040 sheet

Batch: M 104025 LB 07-07-30

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3643

Dwg Rev: PROTO

Prog Rev: TYPE

LB 07-07-30

2-Deburr if necessary

mf

07-08-01.

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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LB 07-07-30

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

Er 070801

(X2)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Form as per Dwg D3643

070807

(2)

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Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



**ENGINEERING
APPROVAL**

WZ
07-08-08



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

N/A. G.M.

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: _____

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/28/15

Job Completion



FOR ENGINEERING USE ONLY

w/o. 00104.

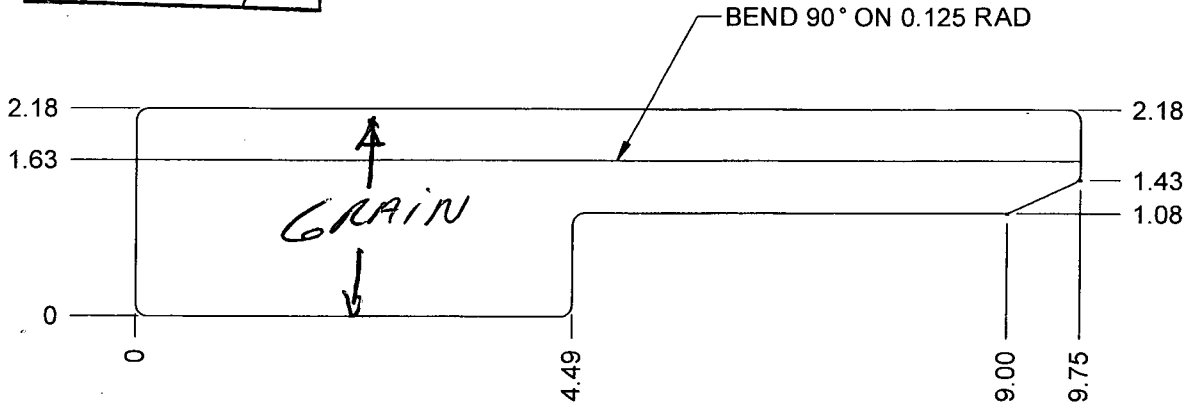
W

07-08-15

Handwritten signature

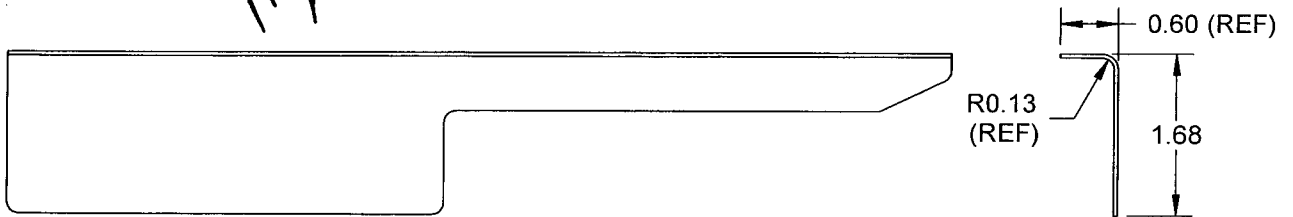
DESIGN DT	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED	DRAWING NO. D3643	REV. A SHEET 1 OF 1
DATE 07.06.28		TITLE STIFFENER SCALE 1:2	
REV A	DATE 07.06.28	DESCRIPTION NEW ISSUE; REPLACES G10610	

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
LE 07-07-17



Est Done. Del. Proj

D3643-1F FLAT PATTERN



D3643-1 STIFFENER (REPLACES GENEVA P/N G10610-1)
D3643-2 OPPOSITE (REPLACES GENEVA P/N G10610-2)

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3643-1/-2" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

